PACE®
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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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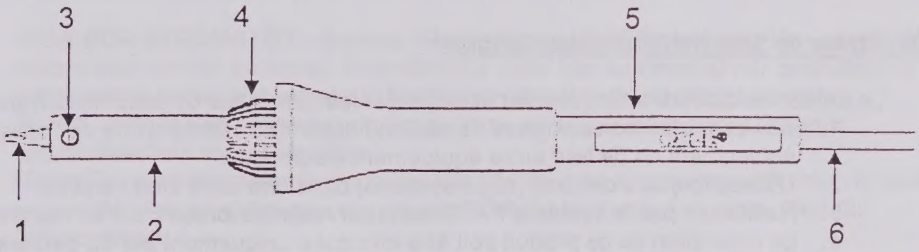
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Française Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

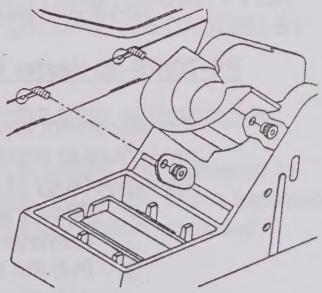
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. Iaktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

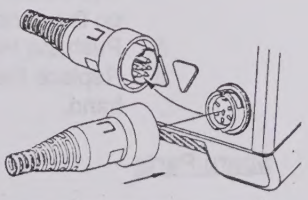
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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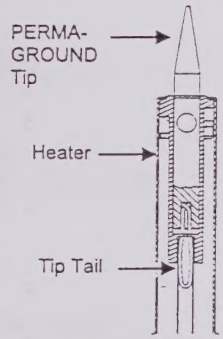
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

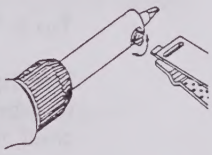


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

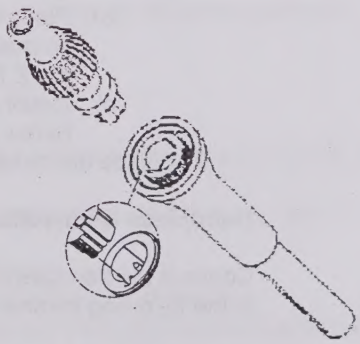
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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Milton Keynes
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TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

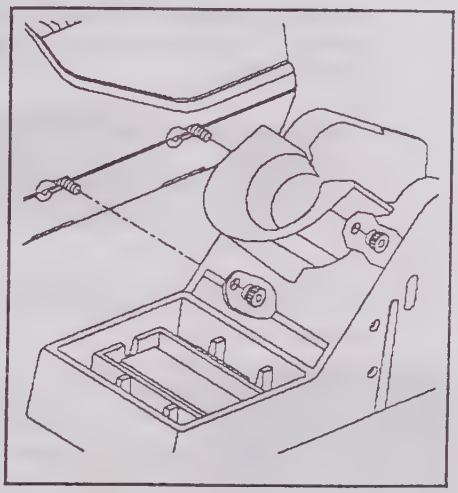
Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



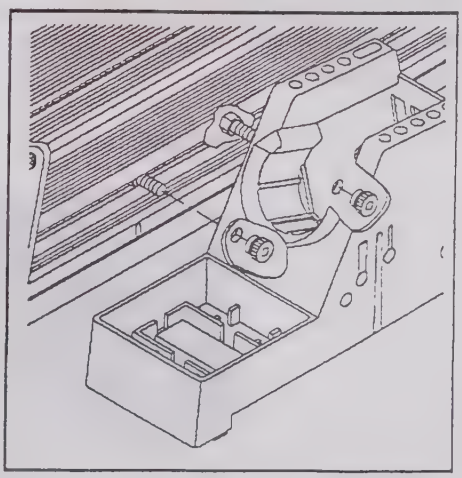
Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



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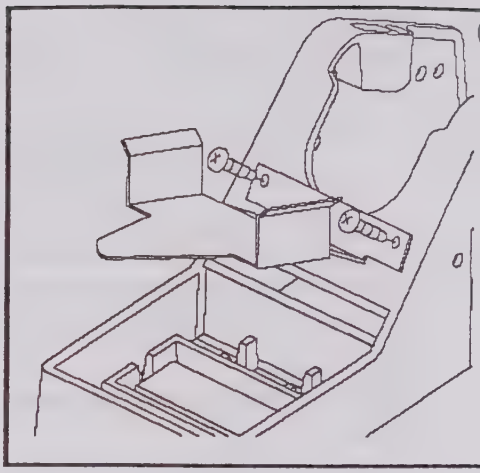
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.



NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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ystem Quick Start
ystème Dé Marrage Rapide
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PACE Pace, Inc ISO

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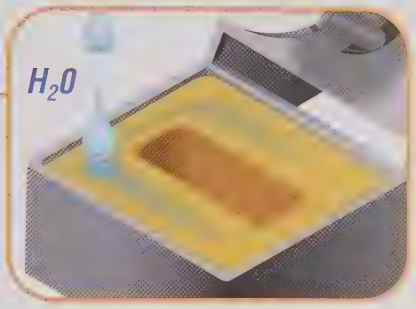

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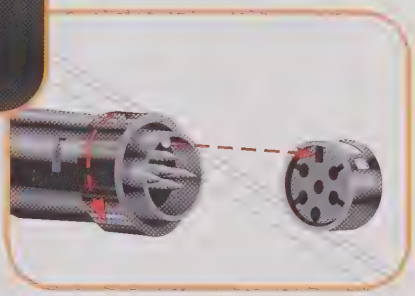

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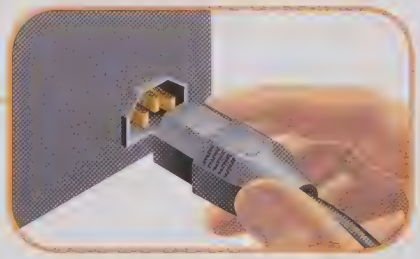

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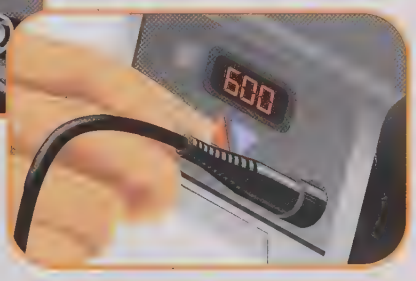

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5050-0469 Rev.B

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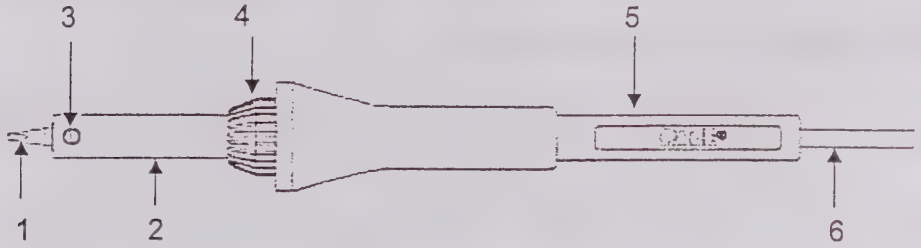

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4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

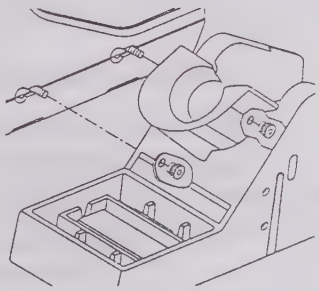
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. Iaktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

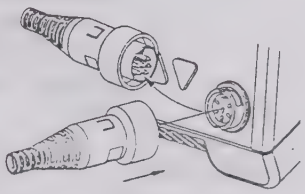
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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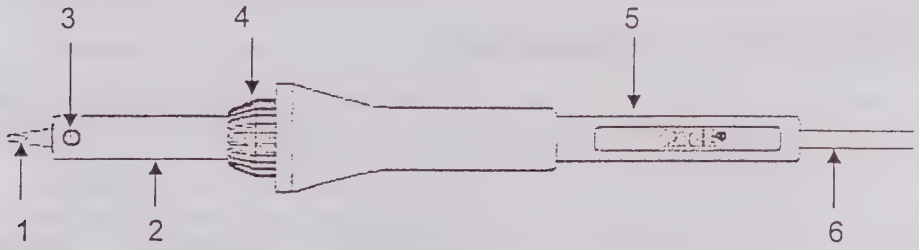
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Francaise Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

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4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
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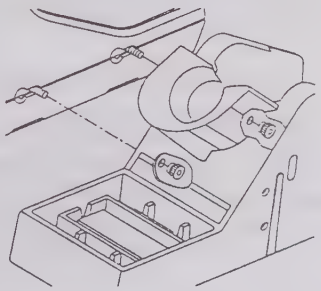
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

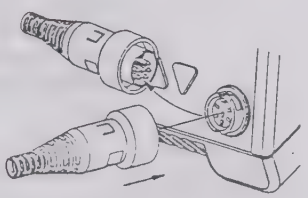
The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.



1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.

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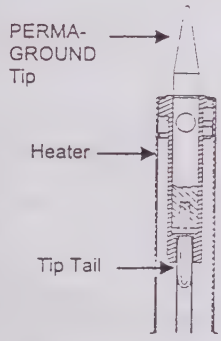
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

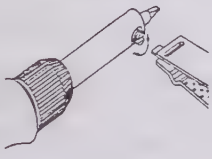


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

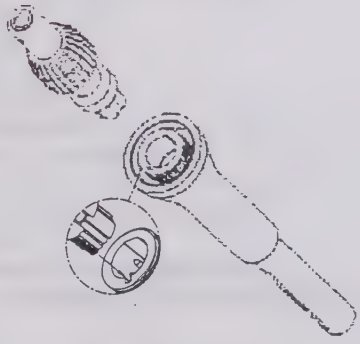
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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Additional copies of this manual or other PACE literature may be obtained from:

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Annapolis Junction, MD 20701
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Milton Keynes
MK1 45BU
United Kingdom

(44) 1908-277666

(44) 1908-277777

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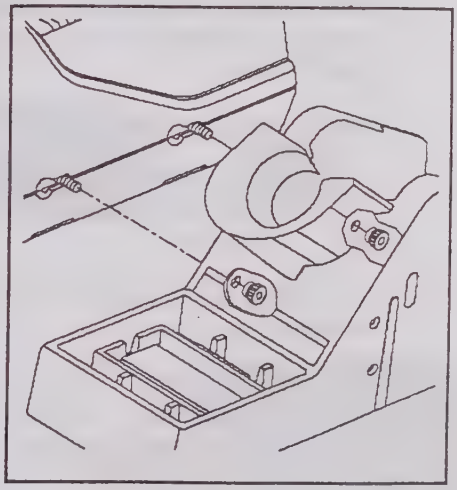
TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

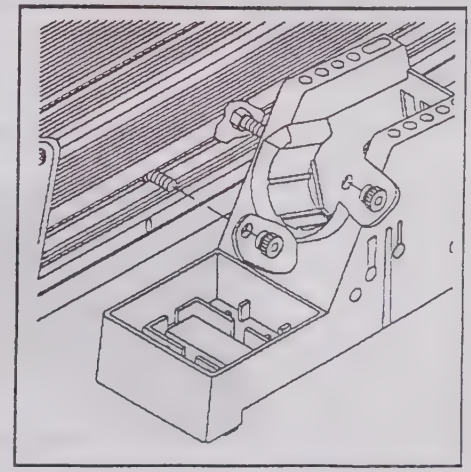


2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.



2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

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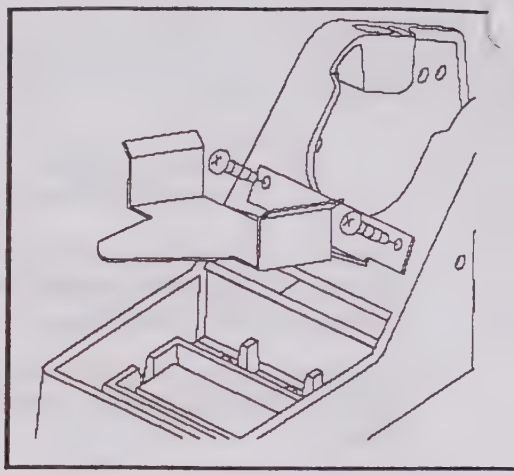
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.

NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.



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ARM-EVAC®, FLO-D-SODR®, MINIWAVE®, PACE®, SENSATEMP®, SNAP-VAC®, SODRTEK®, SODR-X-TRACTOR®, ST 325®, THERMOJET®, THERMOTWEEZ®, VISIFILTER®, THERMO-DRIVE®, and TOOLNET®.

PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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System Quick Start
Système Dé Marrage Rapide
ystem Schnell Start
Avvio Rapido Del Sistema
Início Rápido De Sistema
Inicio Rapido Del Sistema
Snabbstart

1

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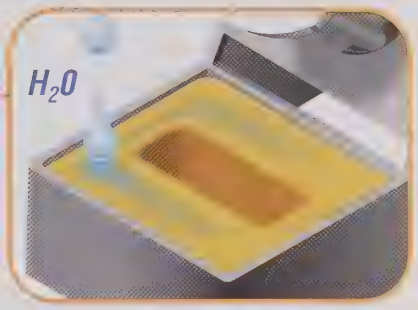

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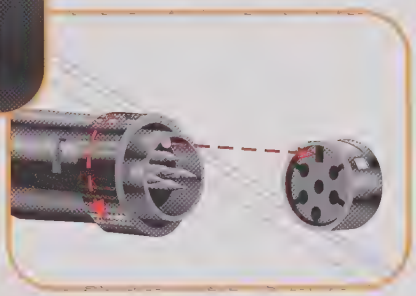

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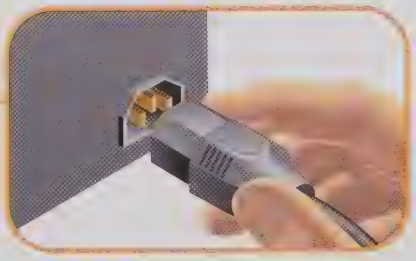

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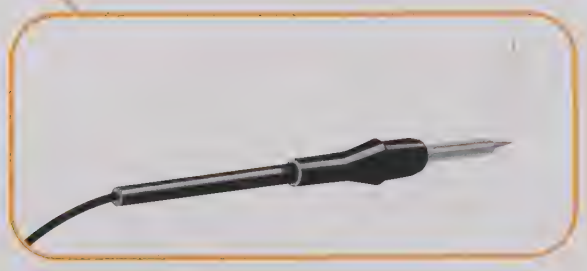

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5050-0469 Rev.B

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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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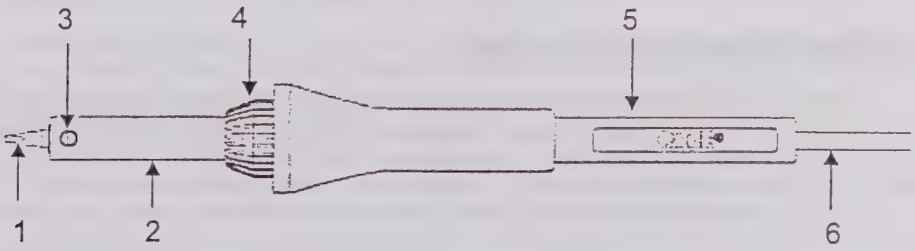
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Francaise Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

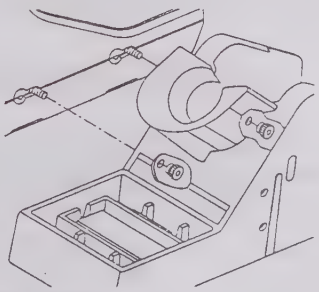
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. Iaktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

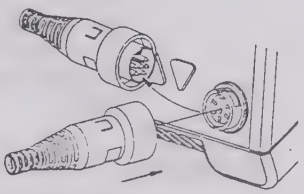
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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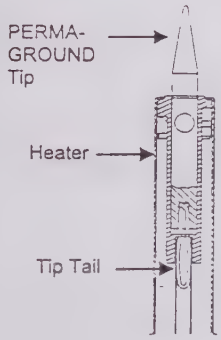
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

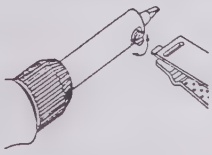


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

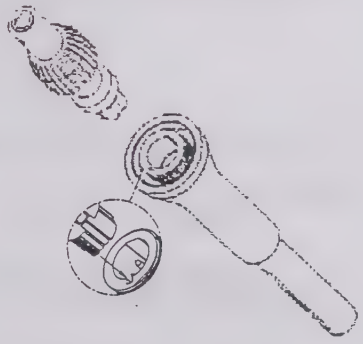
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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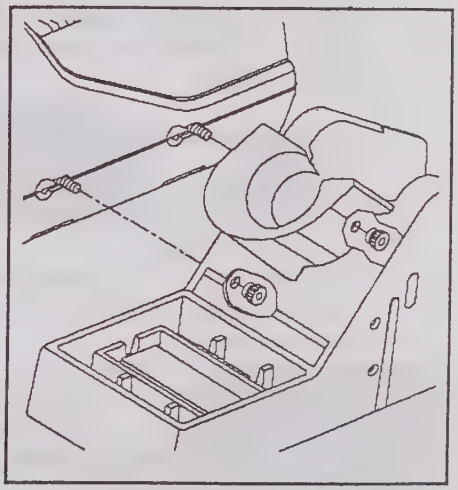
TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

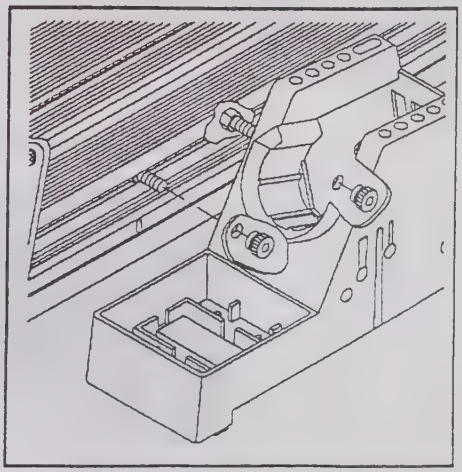
Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.



2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.



1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

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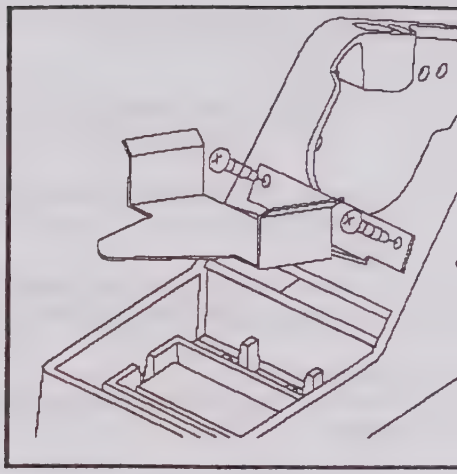
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.



NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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System Quick Start
Système Dé Marrage Rapide
ystem Schnell Start
Avvio Rapido Del Sistema
Início Rápido De Sistema
Inicio Rapido Del Sistema
Snabbstart

PACE Pace, Inc ISO

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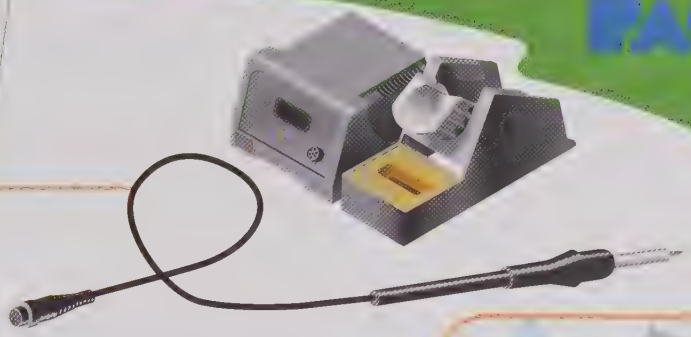

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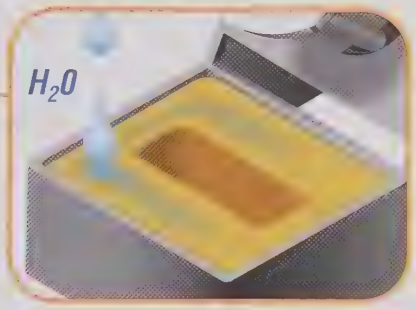

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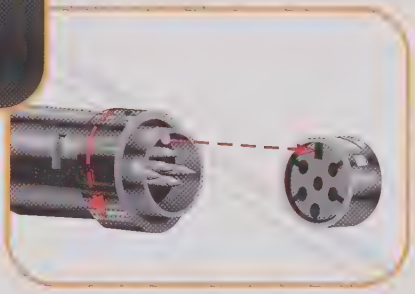

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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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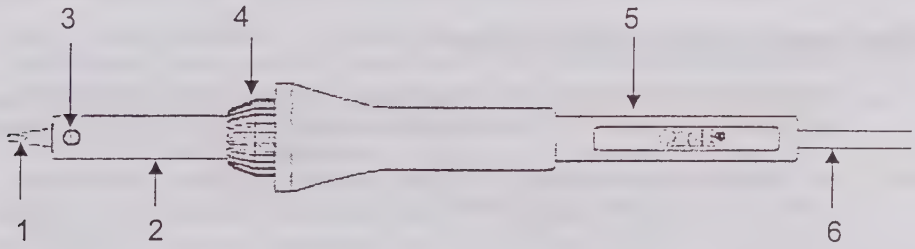

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Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparçoes deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

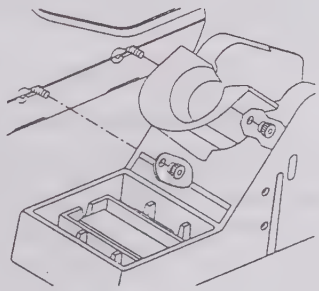
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. laktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

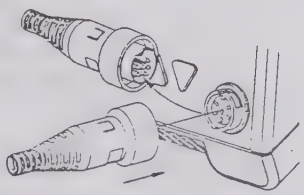
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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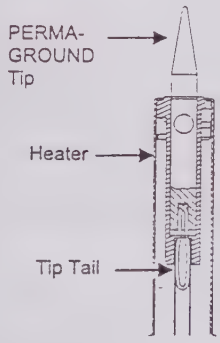
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

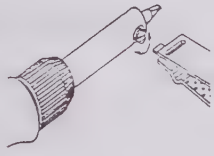


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

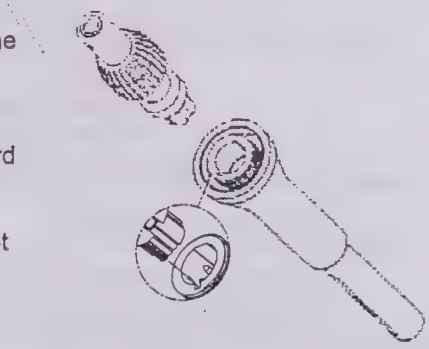
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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United Kingdom

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TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

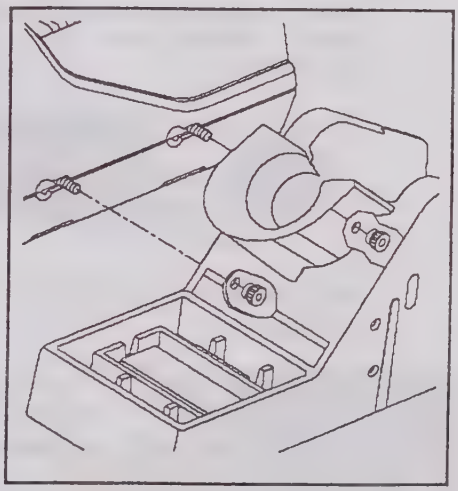
Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



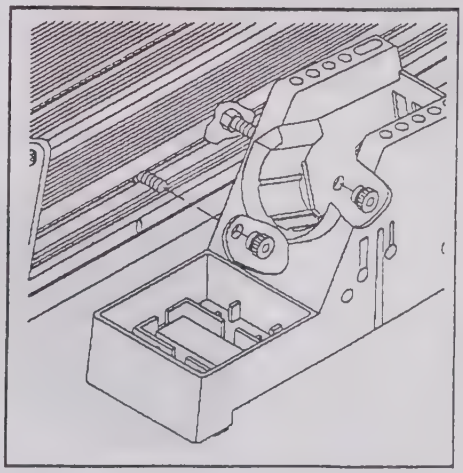
Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



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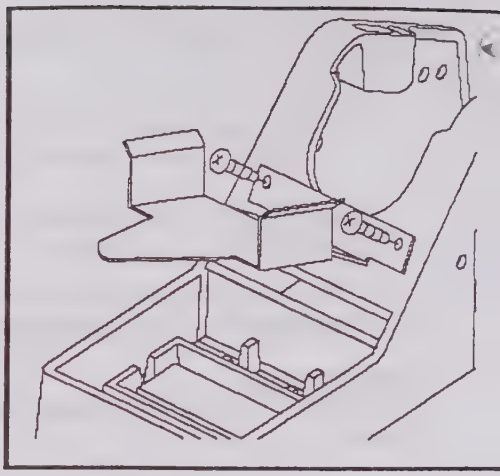
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.

NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.



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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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System Quick Start

Système Dé Marrage Rapide

System Schnell Start

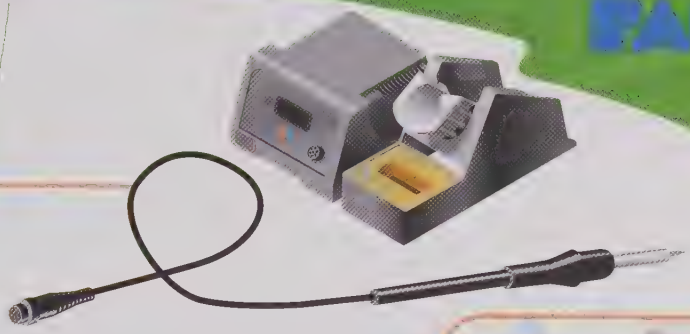
Avvio Rapido Del Sistema

Início Rápido De Sistema

Inicio Rapido Del Sistema

Snabbstart

1



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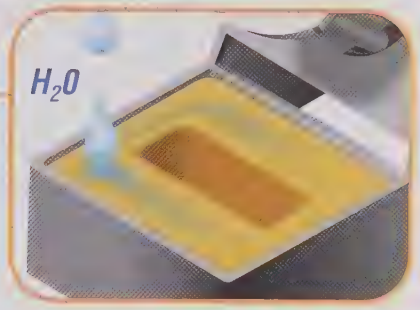

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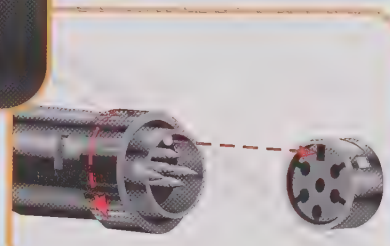

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5050-0469 Rev.B

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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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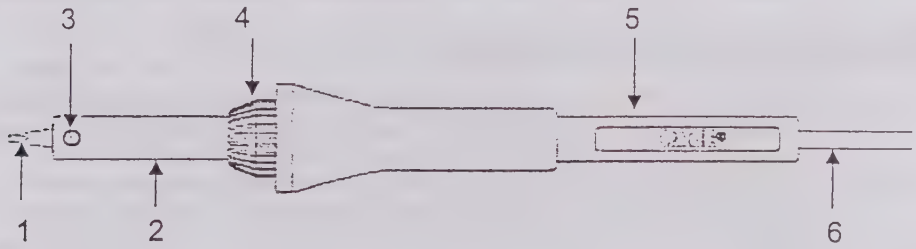
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Française Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

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2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
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3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
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Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

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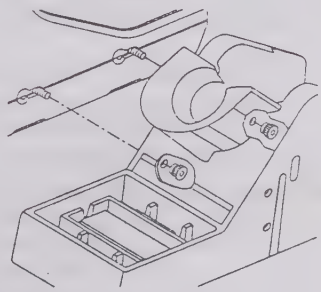
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

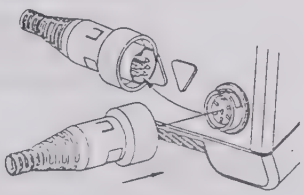
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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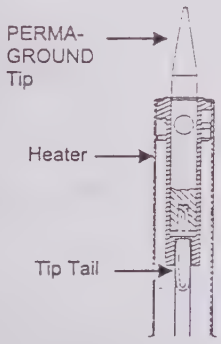
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

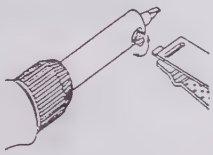


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement

If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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United Kingdom

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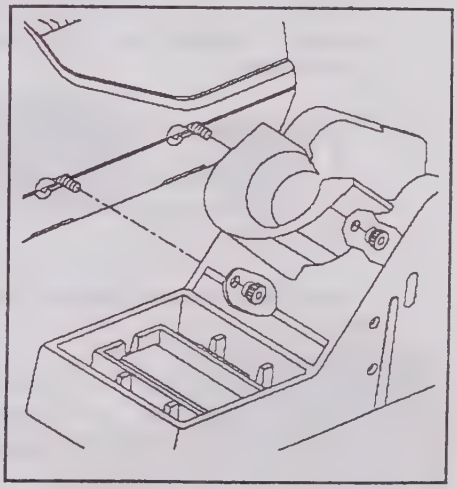
TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

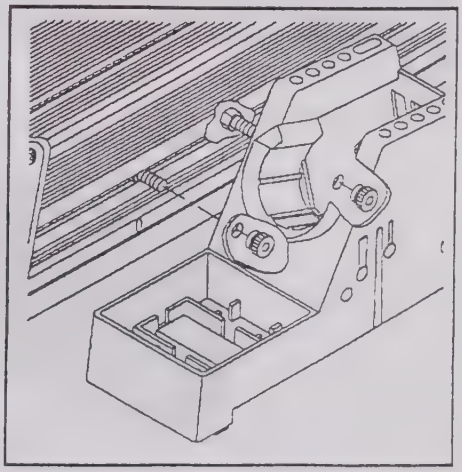
Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.



2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.



1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

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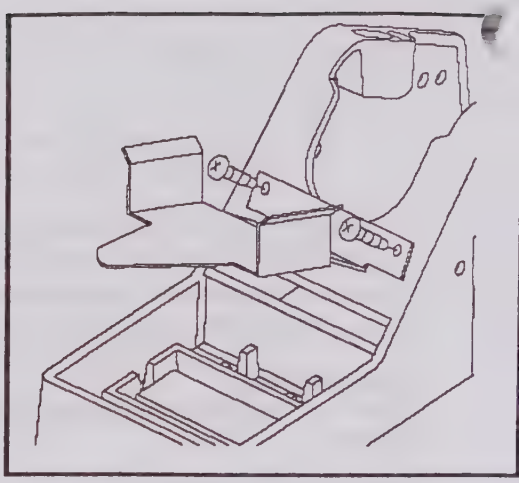
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.

NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.



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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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System Quick Start

Système Dé Marrage Rapide

ystem Schnell Start

Avvio Rapido Del Sistema

Início Rápido De Sistema

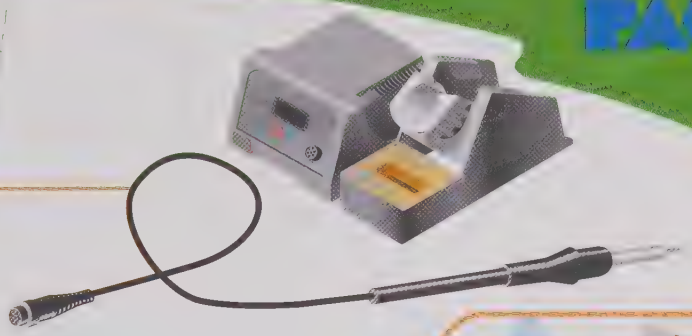
Inicio Rapido Del Sistema

Snabbstart

PACE

Pace, Inc.

1



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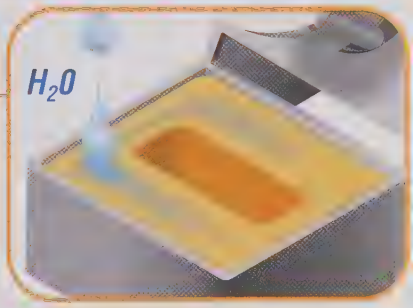

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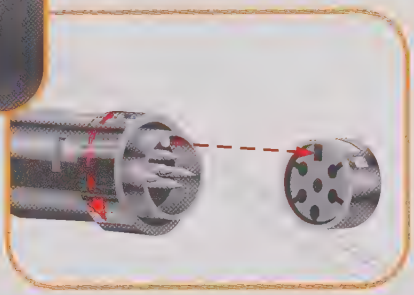

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5050-0469 Rev.

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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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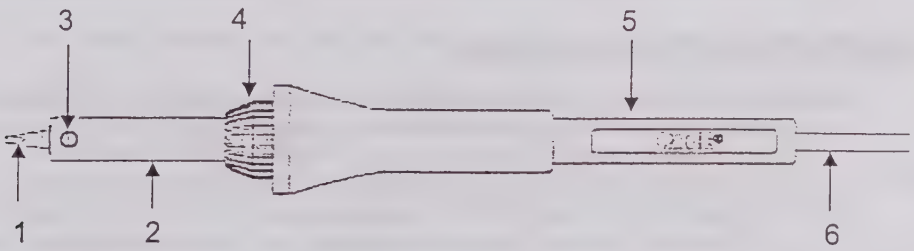
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Française Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

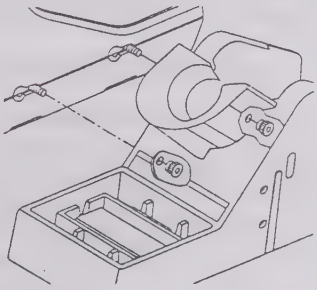
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. Iaktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

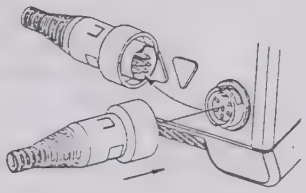
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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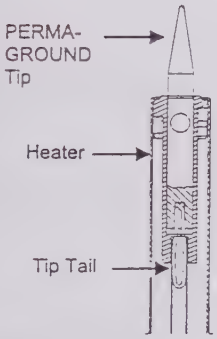
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

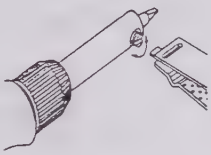


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement

If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

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PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

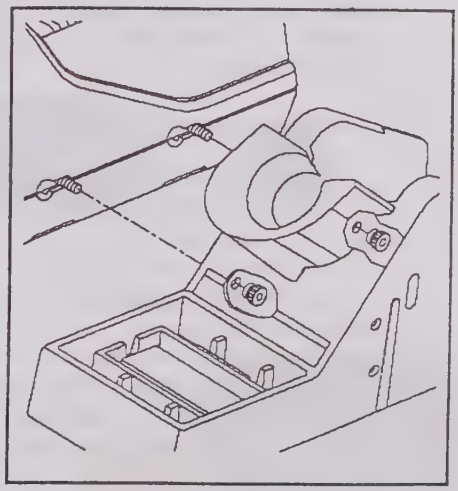
Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



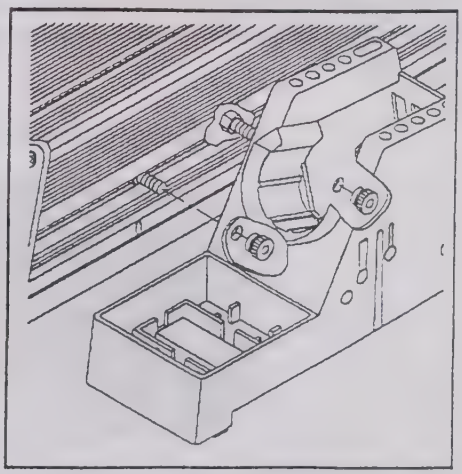
Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



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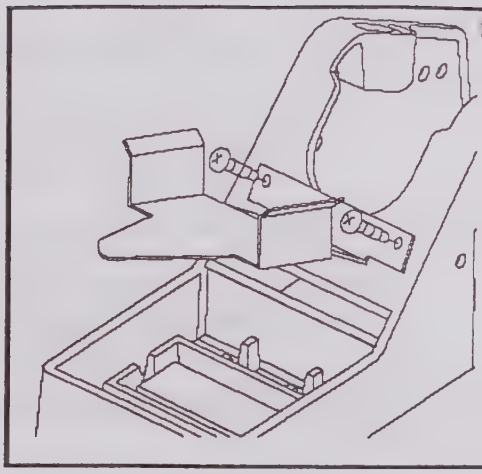
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.

NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.



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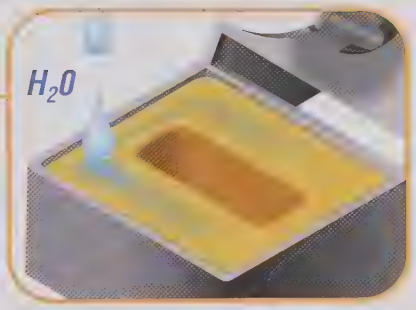
System Quick Start
Système Dé Marrage Rapide
ystem Schnell Start
Avvio Rapido Del Sistema
Início Rápido De Sistema
Inicio Rapido Del Sistema
Snabbstart

1

2



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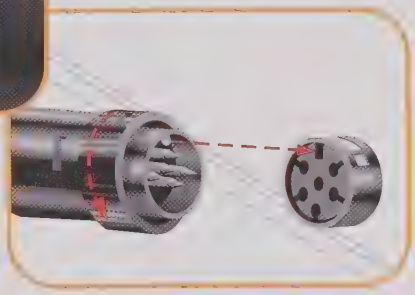

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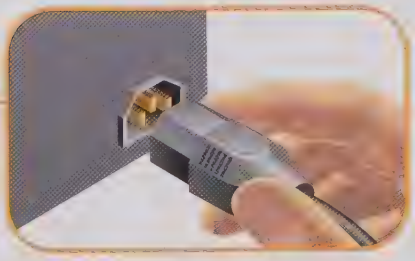

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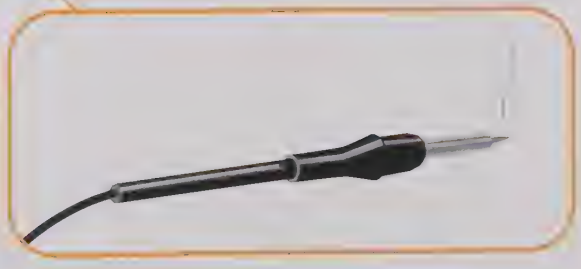

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5050-0469 Rev.B

PACE®
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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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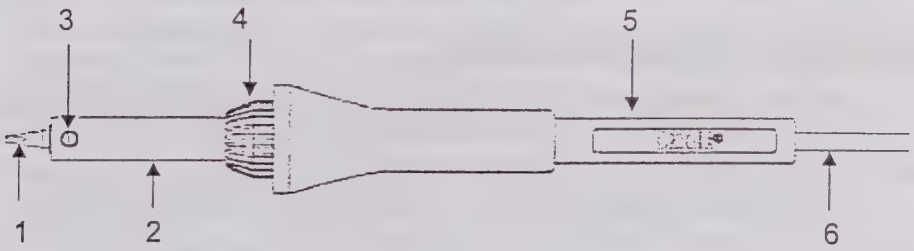
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Française Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

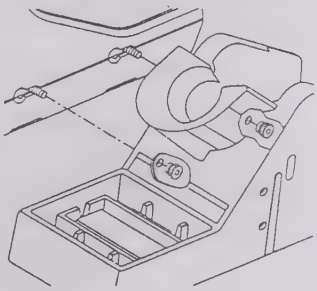
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. laktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskriftema från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

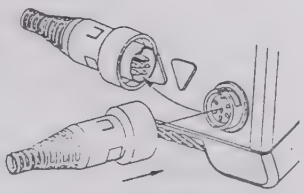
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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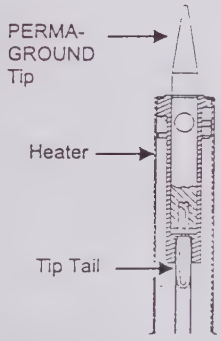
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

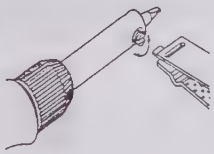


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

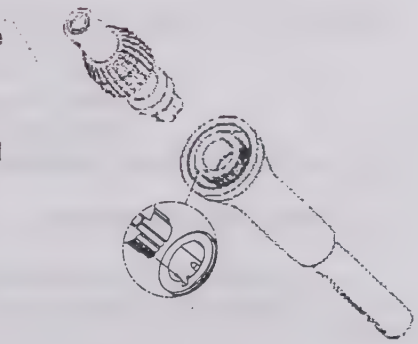
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

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PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

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This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

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PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

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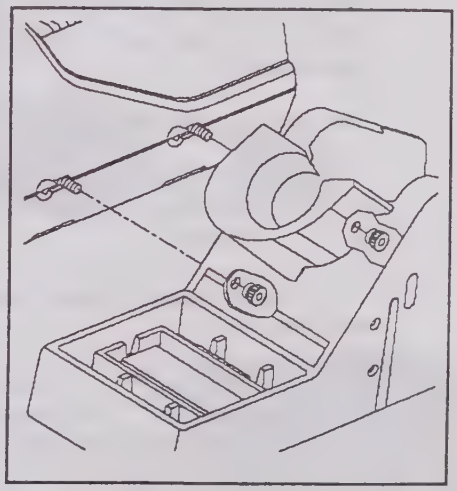
TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

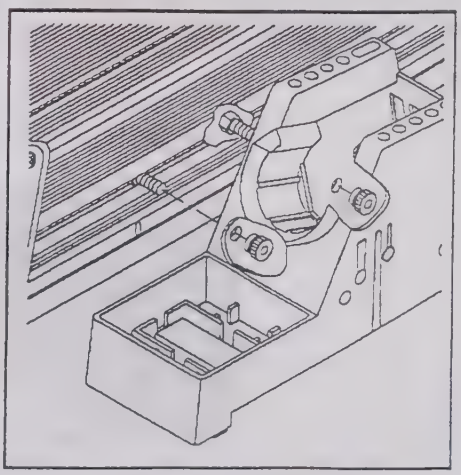


2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.



2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

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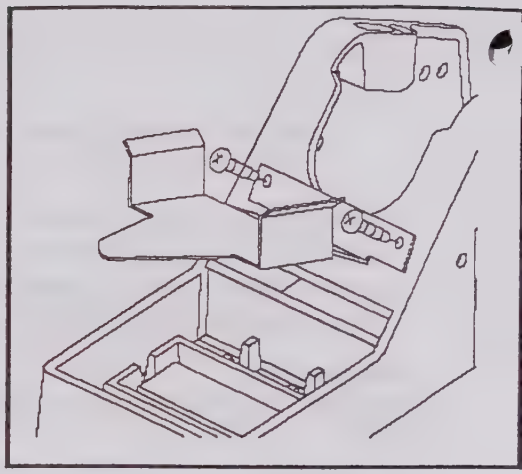
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.

NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.



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System Quick Start

Système Dé Marrage Rapide

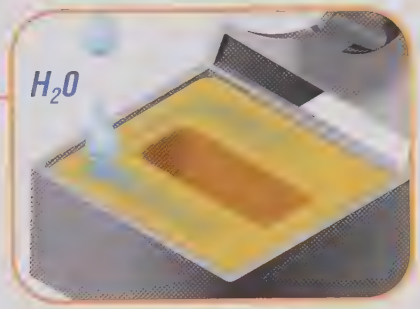
ystem Schnell Start

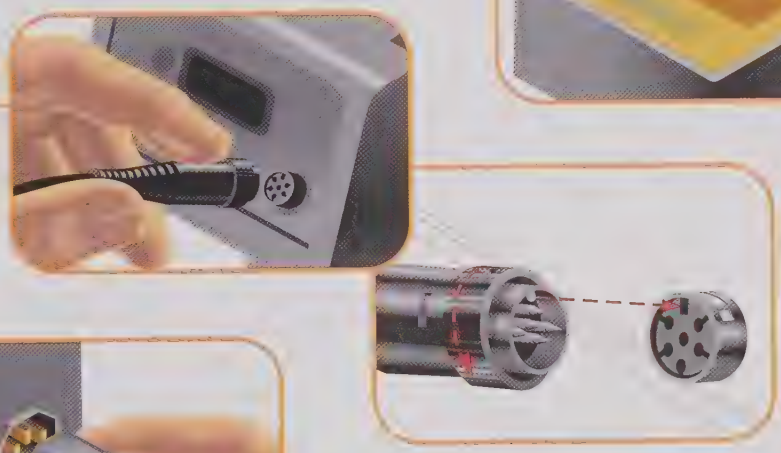
Avvio Rapido Del Sistema

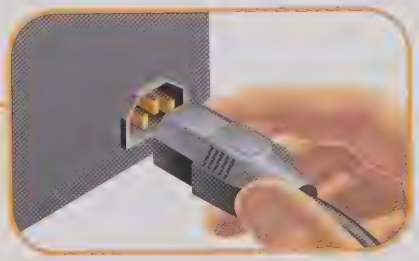
Início Rápido De Sistema

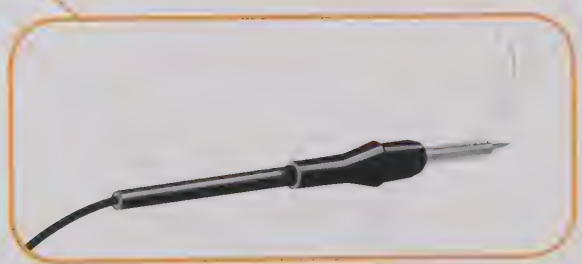
Inicio Rapido Del Sistema

Snabbstart









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5050-0469 Rev.B

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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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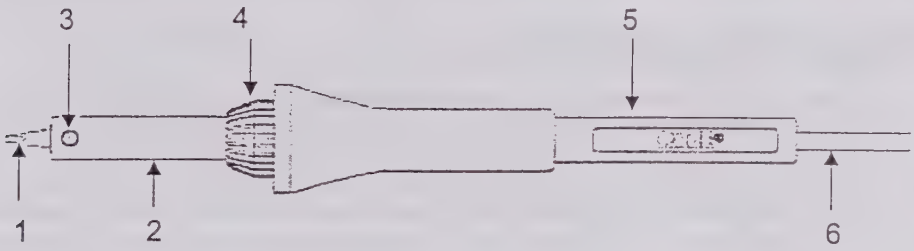
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Française Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

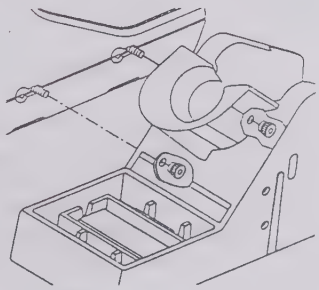
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. laktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

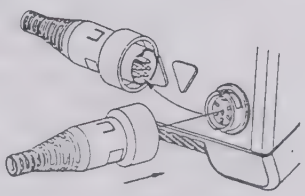
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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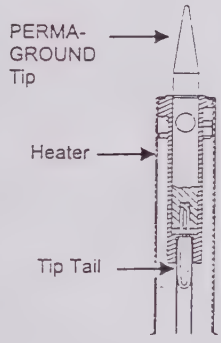
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

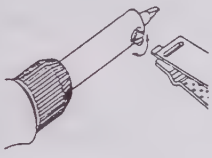


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

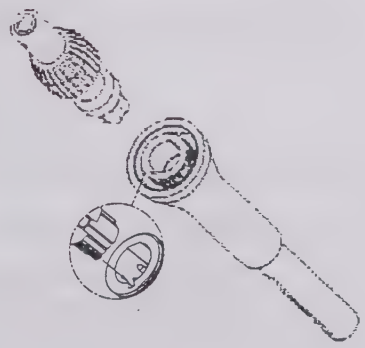
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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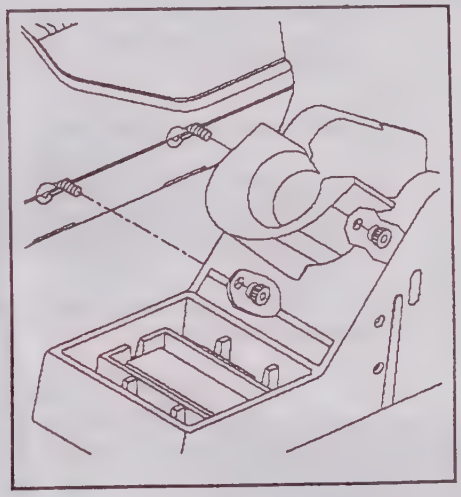
Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



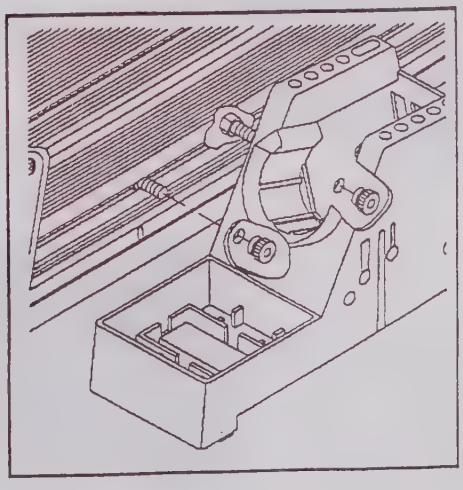
Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



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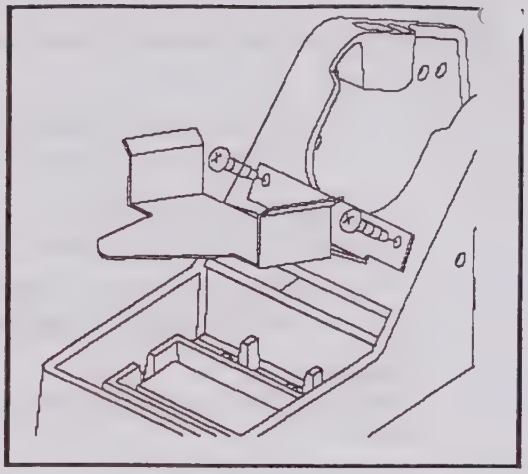
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.



NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.

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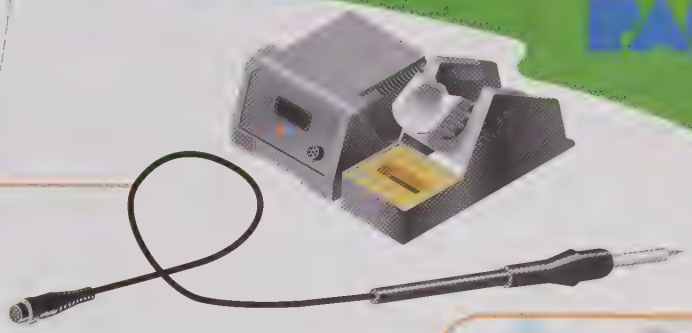
System Quick Start
Système De Marrage Rapide
System Schnell Start
Avvio Rapido Del Sistema
Início Rápido De Sistema
Inicio Rapido Del Sistema
Snabbstart

1



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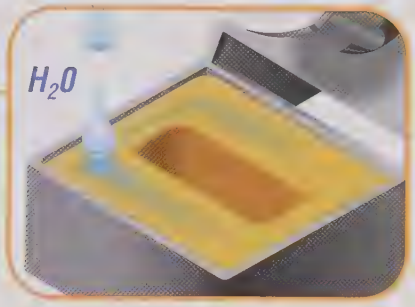

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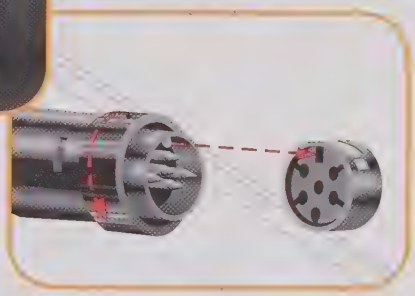

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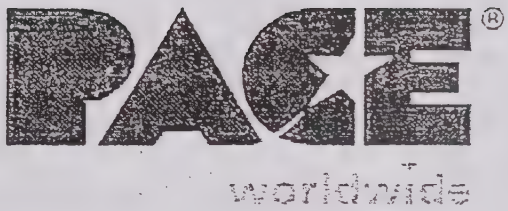

Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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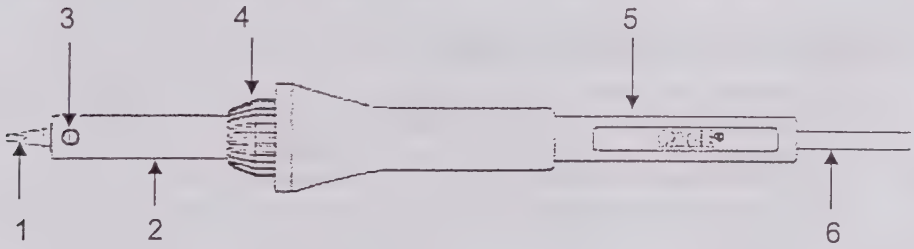
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Francaise Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Lingua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuandò se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

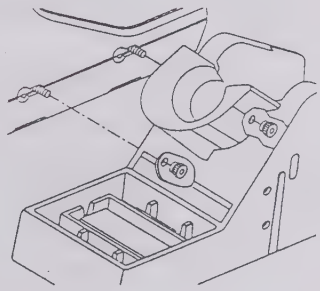
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. Iaktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

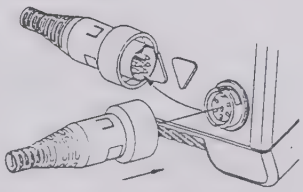
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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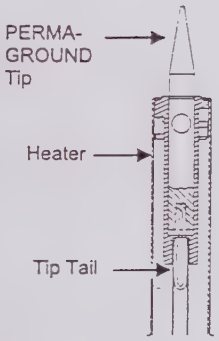
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

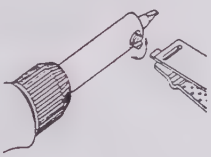


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

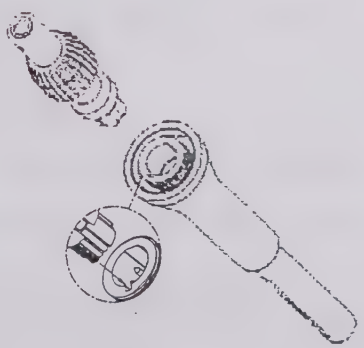
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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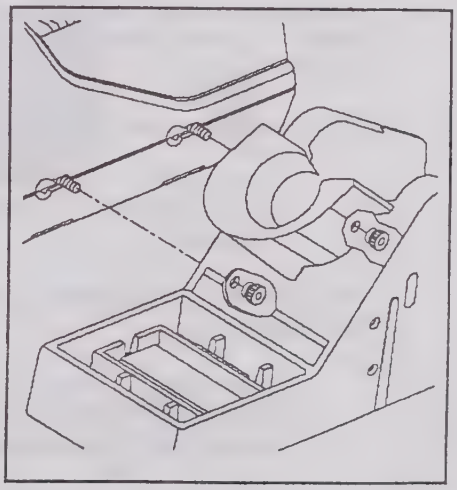
TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

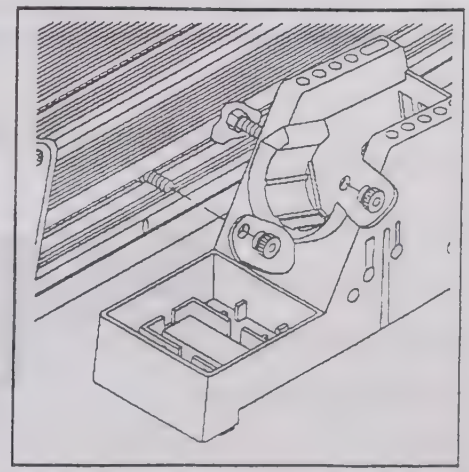
Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.



2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.



1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.

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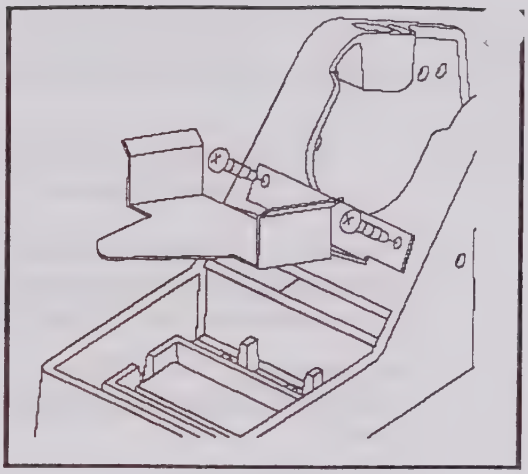
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.



NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.

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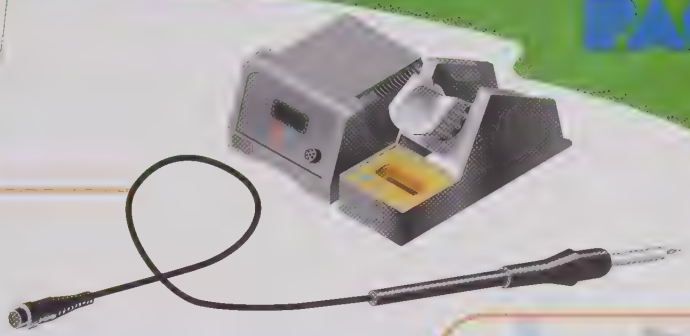

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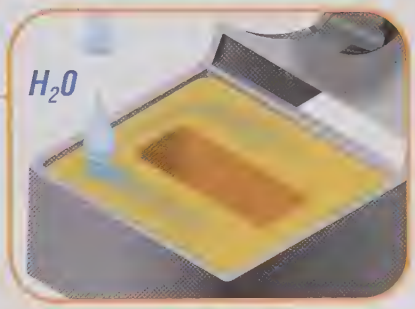

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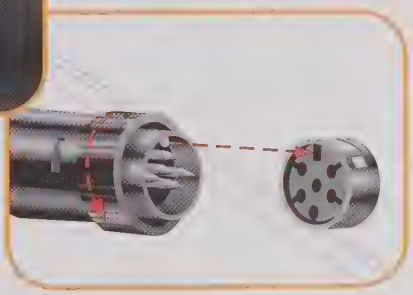

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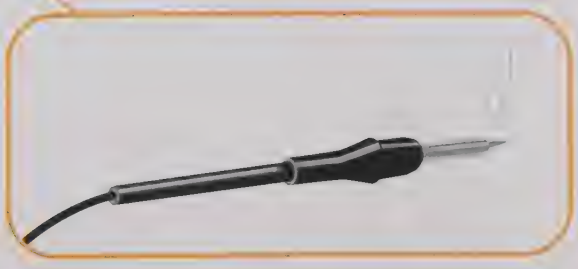

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Operation and Maintenance Manual for the PS-70 & PS-90 Soldering Irons

P/N 5050-0443
Rev C

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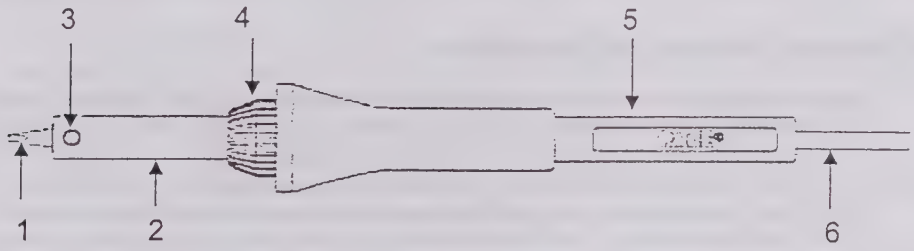
Introduction

Thank you for purchasing the PACE model PS-70 or PS-90 Soldering Irons. These irons should only be used with PACE SensaTemp compatible power supplies. This manual will provide you with the information necessary to properly set up, operate and maintain the PS-70 and PS-90.

Parts Identification



English
1. Tip
2. Heater Assembly
3. Heater Set Screw
4. Heater Retaining Nut
5. Handle
6. Power Cable

Deutsche Sprache
1. Spitze
2. Heizelement
3. Stellschraube für Heizelement
4. Befestigungsmutter für Heizelement
5. Griff
6. Stromkabel

Portuguese Lingua
1. Ponta
2. Conjunto do Aquecedor
3. Parafuso de Ajuste do Aquecedor
4. Porca Retentora do Aquecedor
5. Cabo
6. Cabo de Alimentação

Francaise Langue
1. Panne
2. Assemblage de la résistance de chauffage
3. Vis sans tête de la résistance de chauffage
4. Écrou de fixation de la résistance de chauffage
5. Manche
6. Cordon d'alimentation

Italiana Lingua
1. Punta
2. Resistenza
3. Vite di fissaggio della resistenza
4. Dado di fissaggio della resistenza
5. Maniglia
6. Cavo rete

Espãnol Lenguaje
1. Punta
2. Conjunto calentador
3. Tornillo de fijación del calentador
4. Tuerca de retención del calentador
5. Mango
6. Cable de alimentación

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English Language Safety Guidelines

The following are safety precautions that personnel must understand and follow.

1. Utilize all standard electrical safety precautions when using this or any other electrical equipment.
2. Always use this handpiece (and system) in a well ventilated area.
3. Do not leave the PACE system unattended when in use.
4. Repair on this product should be performed by Qualified Service Personnel only.

Directives de Sécurité, Française Langue

Le personnel doit lire attentivement et respecter les consignes de sécurité suivantes :

1. Suivez toutes les consignes de sécurité électrique standard lors de l'utilisation de cet équipement ou de tout autre équipement électrique.
2. Utilisez toujours cet outil (et ce système) dans une zone bien ventilée.
3. Ne laissez pas le système PACE sans surveillance lorsqu'il est en marche.
4. La réparation de ce produit doit être effectuée uniquement par du personnel d'entretien qualifié.

Sicherheit Korrekturlinien, Deutsche Sprache

Die folgenden Sicherheitsvorschriften müssen vom Personal verstanden und befolgt werden.

1. Alle standardmäßigen Sicherheitsvorschriften für Elektrogeräte müssen beim Einsatz dieses Geräts oder anderer elektrischer Geräte befolgt werden.
2. Dieser Handlötkolben und das System muß immer in einem gut be- und entlüfteten Bereich eingesetzt werden.
3. Das eingeschaltete PACE System darf nicht unbeaufsichtigt gelassen werden.
4. Reparaturen an diesem Produkt dürfen nur von qualifiziertem Personal durchgeführt werden.

Misure di Sicurezza, Italiana Lingua

Le seguenti sono precauzioni di sicurezza che il personale deve intendere e alle quali si deve attenere.

1. Utilizzare tutte le norme standard di sicurezza elettrica nell'adoperare questa o qualunque altra apparecchiatura elettrica.
2. Usare sempre questa impugnatura (e l'intero apparato) in un'area ben ventilata.
3. Non lasciare l'apparato PACE incustodito quando è in uso.
4. Gli interventi di riparazione su questo prodotto devono essere eseguiti esclusivamente da Personale Tecnico Qualificato.

Guidelines de Segurança, Portuguese Linqua

Os tópicos a seguir são precauções de segurança que os operadores devem tomar conhecimento e seguir.

1. Utilize todas as precauções padrões de segurança em eletricidade quando estiver usando este ou qualquer outro equipamento elétrico.
2. Use sempre este soldador (e sistema) em área bem ventilada.
3. Não deixe de tomar cuidado com o sistema PACE enquanto este estiver em uso.
4. As reparções deste produto devem ser realizadas somente por Pessoal Técnico Qualificado.

Guias de Consulta de Seguridad, Espãnol Lenguaje

Estas son las precauciones de seguridad que el personal debe comprender y seguir.

1. Utilice todas las precauciones habituales cuando se trabaja con electricidad al utilizar este o cualquier otro equipo eléctrico.

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2. Utilice siempre este aparato (y sistema) en un área bien ventilada.
3. No deje el sistema PACE sin vigilancia cuando esté en uso.
4. Las reparaciones de este producto deben realizarse solamente por personal de mantenimiento adecuadamente calificado.

Säkerhetsföreskrifter, Svenska

Följande säkerhetsföreskrifter måste förstås och följas av personal som använder eller utför service på PACE produkter.

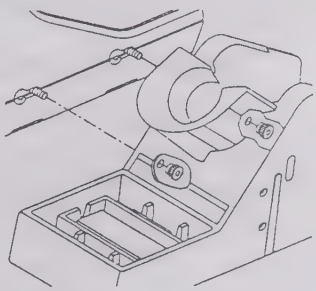
1. **RISK FÖR STRÖMSTÖT** - Service / Reparation av PACE produkter får endast utföras av aktoriserad service personal. Strömförande delar kan kommas åt när produkten är isärplockad. Iaktag aksamhet när felsökning görs för att undvika strömstötar.
2. För att undvika personskada rekommenderas att OSHA eller andra liknande arbetssäkerhets standarder följs.
3. SensaTemp verktygselement och installerade spetsar är heta när strömmen är påslagen och en tid efter att strömmen slagits av. **RÖR EJ** element eller spets. Risk för brännskador!
4. PACE Spets och Verktygshållare är speciellt utformade för att passa PACE respektive verktyg så att risken för brännskador kan undvikas. När verktyget ej används bör det alltid förvaras i sin hållare.
5. Tillse att ventilationen är god där PACE System används. Ett lödröksutsug system som t.ex. PACE tillhandahåller rekommenderas för att skydda användaren för giftig lödrök.
6. Tillse att gällande säkerhetsföreskrifter följs vid användning av kemikalier, t.ex. lodpasta.Se säkerhetsdatabladen som medföljer kemikalierna och följ de rekommenderade säkerhetsföreskrifterna från respektive tillverkare.

Set-Up

Tip & Tool Stand

The Tip & Tool Stand can be mounted to the power source. If the system will be placed on the workbench, this is recommended. If the power source is to be mounted under the workbench or shelf, the Tip & Tool Stand should not be mounted to the power source.

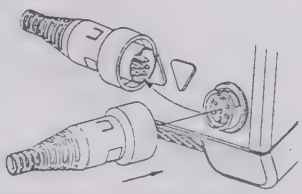
1. To attach the stand to the power source:
   a) Insert the 2 Mounting Screws (head first) into the power source mounting slots (plastic case shown). Slide the screws toward the rear of power source.
   b) Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 Tip & Tool Stand mounting holes shown.
   c) Install a Thumb Nut onto the end of each Mounting Screw and tighten Thumb Nuts.
2. Place the handpiece into its Tip & Tool Stand.



Handpiece Connection

Connect the handpiece connector plug into the Power Receptacle in the following manner.

1. Align guide on connector with slot on power receptacle.
2. Insert connector into power receptacle.
3. Turn the connector housing clockwise to lock in place.



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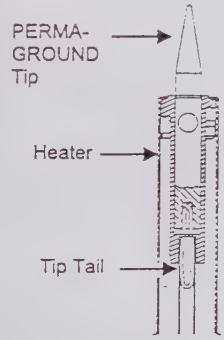
Burn In Procedure

If using a new soldering iron for the first time of it the heater has just been replaced, perform the Heater Burn-In procedure in the power supply manual (or on the red tag on the handpiece) to increase the life expectancy of the heater.

This procedure should be performed whenever a new handpiece or heater is connected to the system.

PS-70/PS-90 Tip Installation

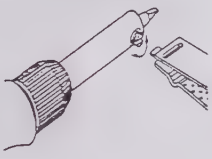


For maximum productivity and proper fit, install tips into your soldering iron when the heater is hot. **CAUTION:** To avoid burns or potential injury, always hold the handpiece with the heater pointed at an angle up to prevent injury.

Installing PERMAGROUND Tips

1. PERMAGROUND Tips should be inserted into the heater with the tail of the tip pointing towards the heater.
2. PERMAGROUND Tips can be used once the tip has been fully inserted into the heater. The set screw is not required to hold the PERMAGROUND Tip in the heater.
3. If proper Tip orientation is required, the set screw can be tightened to hold the tip in place. Also, heat transfer will improve when the set screw is used.

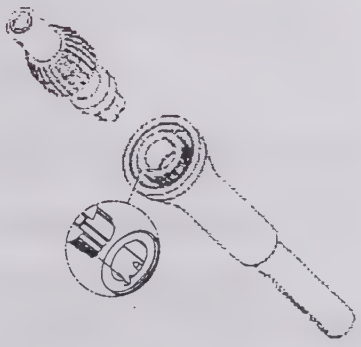
Installing Non-PERMAGROUND Tips



1. Insert the Tip fully into heater bore using the supplied Tip Tool.
2. Gently tighten the heater Set Screw.
3. Recheck the tip Set Screw periodically to insure that it remains snug.

NOTE: Periodically, clean the heater bore with a properly sized wire brush (3/16" O.D. to insure optimum heat transfer and proper tip grounding when non-PERMAGROUND tips are used.

PS-70/PS-90 Heater Replacement



If replacement becomes necessary, perform the following procedure to ensure optimum performance and maximize the life expectancy of the heater.

1. Allow the heater to cool.
2. Remove the Heater Retaining Nut.
3. Pull the Heater Assembly from the Handle. Discard defective Heater Assembly.
4. Align the connector key on the handle end of the replacement Heater Assembly with the keyway slot on the handle.
5. Push the Heater Assembly fully into the handle.
6. Replace the Heater Retaining Nut and tighten by hand.

Spare Parts

Item #	Description	PACE Part Number
1	PS-70 Heater, 21V, 37W	610-0128-P1

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2	PS-90 Heater, 21V, 51W	6010-0095-P1
3	Retaining Nut for PS-70/PS-90	1410-0122-P5

Service

Please contact PACE or your local distributor for service and repair.

Warranty Information:

LIMITED WARRANTY

PACE warrants that this equipment will be free of defects in materials and workmanship for a period of one (3) years from the date of receipt by original purchaser.

This warranty does not cover repair or replacement required as a result of misuse, mishandling or improper storage. Failure to perform recommended routine maintenance, alterations or repairs made other than in accordance with PACE's directions, or removal or alteration of identification plates in any way will void this warranty. This warranty is available only to the original purchaser, but the exclusions and limitations therein apply to all persons and entities.

This warranty does not apply to consumable items, such as tips, filter elements, hoses, collection chambers, heaters, etc.

PACE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

PACE will, at its option, repair or replace any defective equipment or parts at its facility or other location approved by PACE at no charge to the user, or provide parts without charge for installation by the user in the field at user's expense and risk. User will be responsible for all costs of shipping equipment to PACE or other warranty location for warranty service.

EXCEPT FOR THE REMEDY ABOVE DESCRIBED, UNLESS OTHERWISE REQUIRED BY APPLICABLE LAW, PACE WILL HAVE NO OTHER OBLIGATION WITH REGARD TO ANY BREACH OF WARRANTY OR OTHER CLAIM WITH RESPECT TO THE EQUIPMENT, OR LIABILITY FOR ANY DIRECT, INDIRECT, CONSEQUENTIAL, OR INCIDENTAL LOSS OR DAMAGE CAUSED BY OR OCCURRING IN CONNECTION WITH ANY OF THE EQUIPMENT.

Do NOT return defective equipment or parts to PACE without obtaining prior authorization.

Any warranty or other claim with respect to the equipment must be made in writing and delivered to PACE (or local authorized PACE Distributor outside the U.S.) within a reasonable time of the expiration date of this warranty. Sufficient evidence of purchase and date of receipt must also be included, otherwise user's rights under this warranty shall be deemed waived.

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TIP & TOOL STAND KITS
INSTALLATION INSTRUCTIONS
MANUAL NUMBER 5050-0357 REV. G

The following instructions provide the user with the information necessary to install any of the PACE Tip & Tool Stand Kits. PACE Tip & Tool Stands may be installed in any of the following configurations:

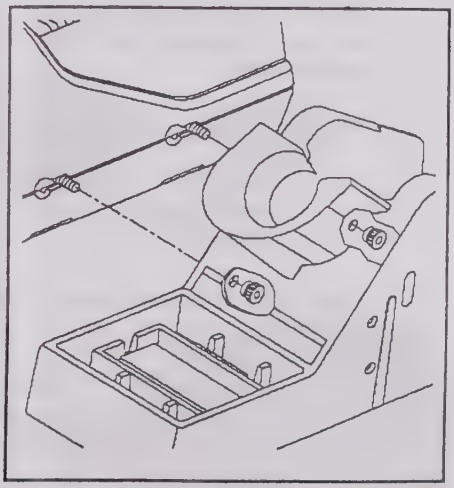
Free Standing
The Tip & Tool Stand may be used as a freestanding unit and placed in any location adjacent to the PACE power source.

Stand/Stand Mounting
Tip & Tool Stands may be attached together by simply placing the 2 stands beside each other, inserting the 2 Mounting Screws through matching mounting holes in the stands and securing with the 2 Thumb Nuts.

Power Sources With Plastic Cases
Attach the stand to the power source, using the following procedure.
1. Insert the 2 Mounting Screws (head first) into the 2 power source mounting slots shown. Slide the screws toward rear of power source.

2. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes. All other mounting holes will not be used.

3. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position. You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



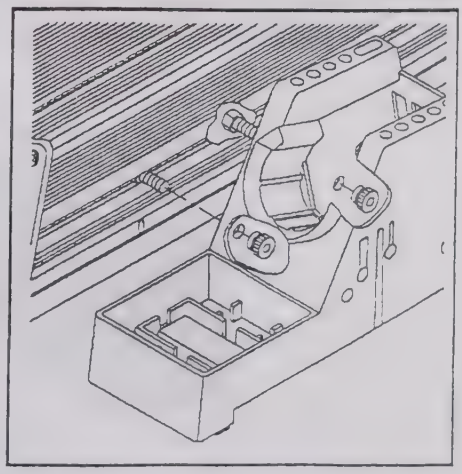
Power Sources With Metal Cases
Attach the stand to the power source, using the following procedure. Refer to illustration.

1. Insert the 2 enclosed hex head Mounting Screws into the slot on the side of the Power Source. Some kits may contain 4 mounting screws; 2 with small heads and 2 with large heads. Use the 2 screws that fit properly in the slot. Also, some Power Source cases have more than 1 slot; use the lower slot.

2. Position the Mounting Screws to the rear of the power source and spaced approximately 2 inches apart. Refer to illustration.

3. Place the Tip & Tool Stand beside the power source. Insert ends of the 2 Mounting Screws into the 2 adjacent Tip & Tool Stand mounting holes.

4. Install a Thumb Nut onto the end of each Mounting Screw. Tighten Thumb Nuts to secure the Tip & Tool Stand in position.
You may wish to set the Power Source on its side and remove the drip tray to ease installation of the Thumb Nuts.



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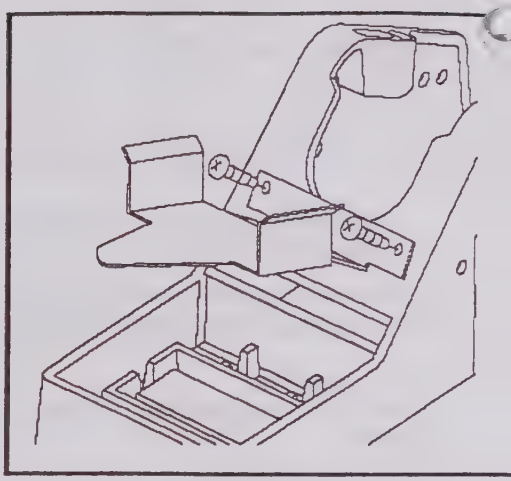
ThermoTweez Bracket

If you have a DTP or TT Tip & Tool Stand (for Dual ThermoPik or ThermoTweez handpiece), a bracket and mounting hardware have been enclosed. Position the Bracket onto the Tip & Tool Stand as shown. Secure in position using the two mounting screws supplied.



NOTE
Some Tip & Tool Stands are shipped with the Bracket already installed.

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PACE products meet or exceed all applicable military and civilian EOS/ESD, temperature stability and other specifications including MIL STD 2000, ANSI/JSTD 001, IPC7711, and IPC A-610.

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System Quick Start

Système Dé Marrage Rapide

ystem Schnell Start

Avvio Rapido Del Sistema

Início Rápido De Sistema

Inicio Rapido Del Sistema

Snabbstart

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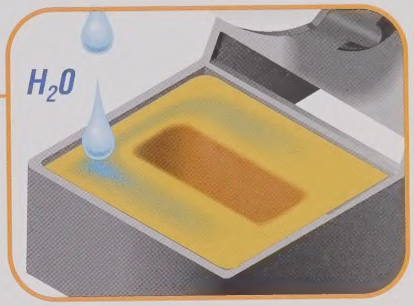

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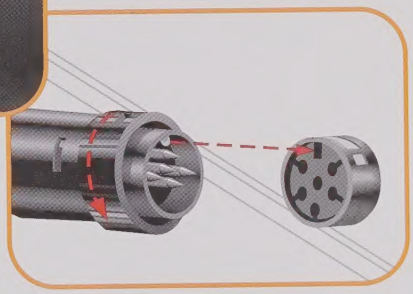

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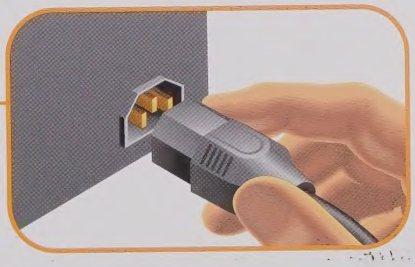

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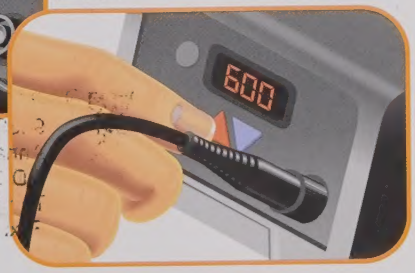

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DELUXE VIEW BINDERS
1/2" ROUND RING

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20702	WHITE
20703	BLUE